



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBW1205G00231-3G

Job Sheet 190257



Part No: RBW1205G00231-3G

Job Qty: 3 pcs *4 MLC*

8897

Part Name: Main Rotor Damper Oil Filling Adapter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/6/19

Job Tracking No: SIOP

Due Date: 3/15/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG RBW1205G00231-3G Rev 2B IPP Rev A 18.02.14m New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	3 pcs	3/15/19		0.25	0.75	Small Fab - 1		<i>MLC</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	3 pcs	3/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	Packaging 3-1 - Stock - B4B	3 pcs	3/15/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



Container No: S166589



Part: RBW1205G00231-3G

Job No: 190257

Serial No/Batch: S166589

Revision: 2B

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/26/19

DAS 40 9-89
MAR 26 2019

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	DAS
				Packaging 3 - 8 - B4B	28
				Packaging 3 - 9 - B4B	9-89
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
140	QC 21 - FG	3 pcs	3/15/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53
MAR 27 2019					

Part Op **100** - (Small Fab) Assemble as per DWG.
 Descriptions: **110** - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

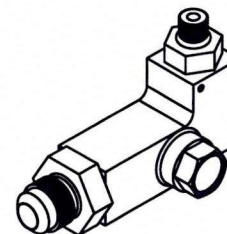
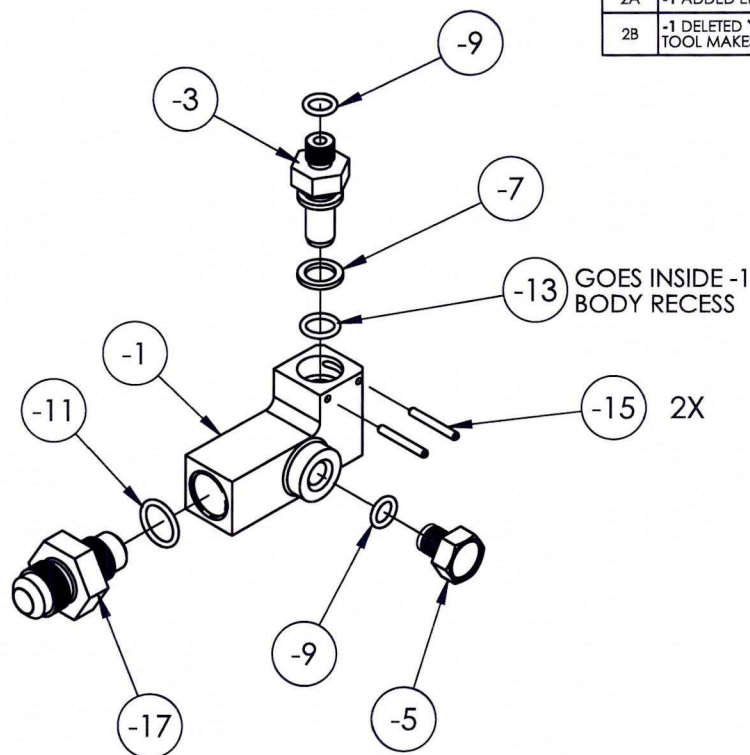
Part / Item	Component Name	Quantity	Operation	Container
91611A108	Spring Pin 2mmRND x 18mm	6 Ea (2 ea)	100-Small Fab - 1	5004183
AN815-6D	Union M Flare	3 Ea (1 ea)	100-Small Fab - 1	5107741
RBW1205G00231-3G-1	Body	3 pcs (1 ea)	100-Small Fab - 1	5162813
RBW1205G00231-3G-3	Tube	3 pcs (1 ea)	100-Small Fab - 1	3x 5063289
RBW1205G00231-3G-5	Pressure Relief Plug (Modified B/O)	3 pcs (1 ea)	100-Small Fab - 1	5163240
RBW1205G00231-3G-7	Washer	3 pcs (1 ea)	100-Small Fab - 1	50921196
V75-010	Oring	6 Ea (2 ea)	100-Small Fab - 1	5038451
V75-011	Viton 75D Brown Oring	3 Ea (1 ea)	100-Small Fab - 1	5038453
V75-013	Viton 75D Oring	3 Ea (1 ea)	100-Small Fab - 1	5038452

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	91611A108	6	89	0
	AN815-6D	3	11	0
	RBW1205G00231-3G-1	3	0	0
	RBW1205G00231-3G-3	3	5	0
	RBW1205G00231-3G-5	3	0	0
	RBW1205G00231-3G-7	3	23	0
	V75-010	6	12	0
	V75-011	3	15	0
	V75-013	3	15	0
Part Specifications				
Specifications could not be found.				

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED PART -17, -1 REMOVED 7/16-20 THREADED NIPPLE, MOVED RELIEF VALVE .100.	2/24/2011	JAG	
2	-1 CH'D TO USE PORTING TOOL 2 PLACES.	12/20/2011	JAG	
2A	-1 ADDED ENGRAVE NOTE PER S.E.	3/28/2012	RJC	SE
2B	-1 DELETED $\nabla \varnothing .37 \times 90^\circ$, NEAR SIDE CALLOUT FROM 5/16-24 $\nabla .50$ BECAUSE 5/16-24 PORTING TOOL MAKES THIS FEATURE	1/21/2014	DPD	GE



FUNCTION: PART OF HELICOPTER SERVICING KIT T/N 3G1205G00131.
USED IN CONJUNCTION WITH A MANUAL HYDRALIC OIL PUMP TO
RESTORE THE HYDRAULIC OIL LEVEL INTO THE M/R DAMPER

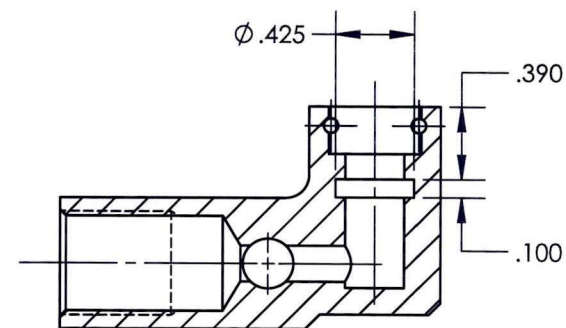
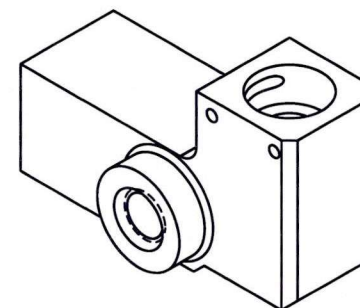
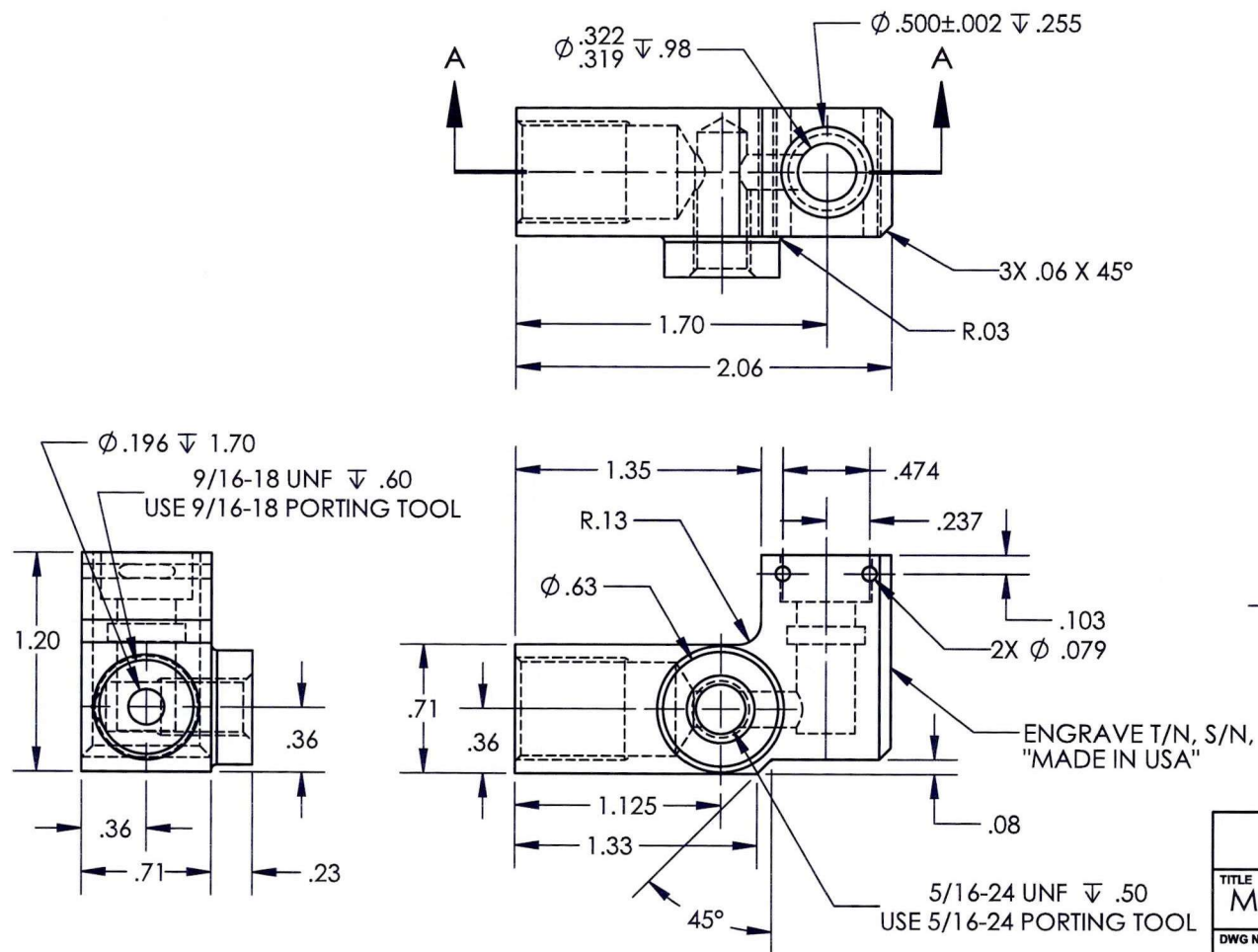
ORIGINAL No. REF
 RBW1205G00231-3G = 3G1205G00231
 RBW1205G00213-3G-1 = 3G1205G00651
 RBW1205G00231-3G-3 = 3G1205G00551
 DO NOT USE, FOR REGERENCE ONLY

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BODY	6061	1-1/8 X 1-3/8 X 2-3/16	2
			-3	1	TUBE	6061	$\varnothing 3/4 \times 1-1/2$	3
			-5	1	AN PRESSURE RELIEF PLUG	ALUMINUM	AIRCRAFT SPRUCE #AN814-2D (MODIFIED)	4
			-7	1	WASHER	NYLON	$\varnothing 1/2 \times 3/16$	5
		B/O	-9	2	O-RING	VITON	ID 1/4 X 1/16 WIDTH #V75-010	1
		B/O	-11	1	O-RING	VITON	ID 7/16 X 1/16 WIDTH #V75-013	1
		B/O	-13	1	O-RING	VITON	ID 5/16 X 1/16 WIDTH #V75-011	1
		B/O	-15	2	ROLL PIN	STEEL	$\varnothing 2\text{mm} \times 18\text{mm}$ McMaster-Carr #91611A108	1
		B/O	-17	1	FITTING	ALUMINUM	MS24392D6	1

RED BARN MACHINE	
TITLE MAIN ROTOR DAMPER OIL ADAPTER	
DWG NO. RBW1205G00231-3G	REV 2B
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX ± .005 FRACTIONS ± 1/32 XX ± .01 ANGLES ± 5° X ± .1	DRAWN BY: PERRITT APPROVED: <i>D Weir</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AGUSTA
SCALE 1:2	DATE 2/23/2011
SHEET 1 OF 5	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-1 REMOVED 7/16-20 THREADED NIPPLE, MOVED RELEIF VALVE .100.	2/24/2011	JAG	
2	-1 CH'D TO USE PORTING TOOL 2 PLACES.	12/20/2011	JAG	
2A	-1 ADDED ENGRAVE NOTE PER S.E.	3/28/2012	RJC	SE
2B	-1 DELETED $\sqrt{\phi .37 \times 90^\circ}$, NEAR SIDE CALLOUT FROM 5/16-24 $\sqrt{.50}$ BECAUSE 5/16-24 PORTING TOOL MAKES THIS FEATURE	1/21/2014	DPD	GE



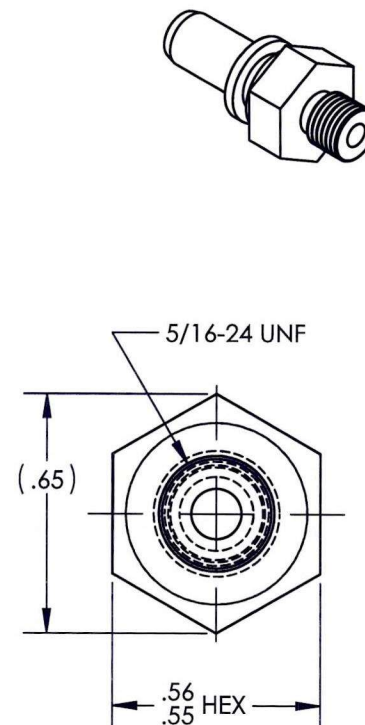
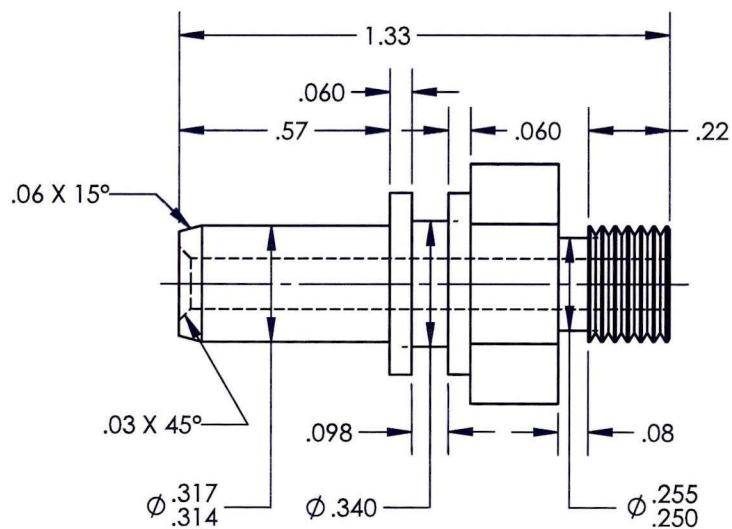
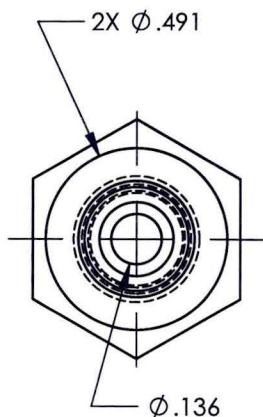
SECTION A-A
SCALE 1 : 1

(-1)
BODY

RED BARN MACHINE	
TITLE MAIN ROTOR DAMPER OIL ADAPTER	
DWG NO. RBW1205G00231-3G-1	REV 2B
MAT'L 6061	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED: <i>D Weil</i>
.XXX $\pm .005$	HEAT TREAT
.XX $\pm .01$	FINISH CLEAR ANODIZE
.X $\pm .1$	SPEC MIL-A-8625F, TYPE II, CLASS I
1. BREAK ALL SHARP EDGES .015 x 45°	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AGUSTA
SCALE 1:1	DATE 2/23/2011
SHEET 2 OF 5	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



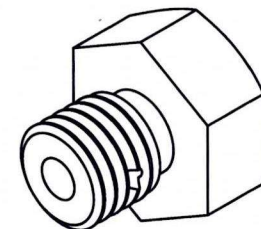
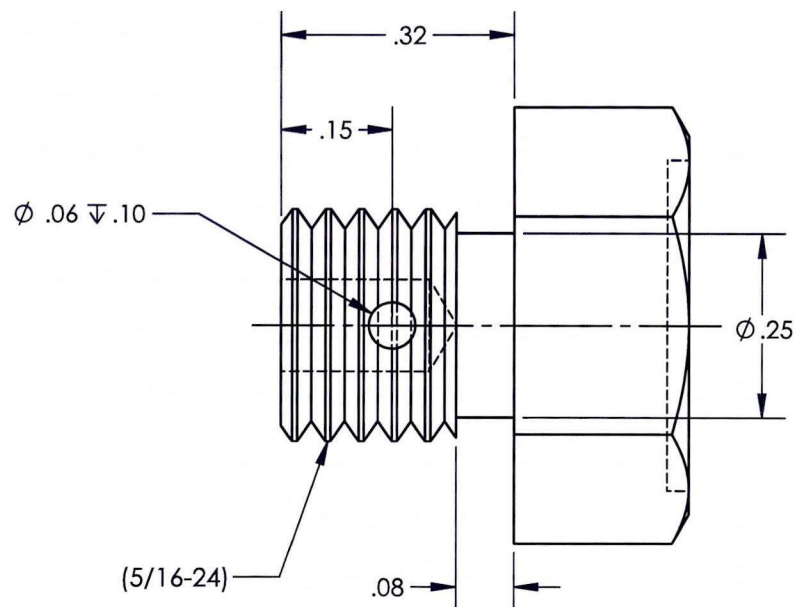
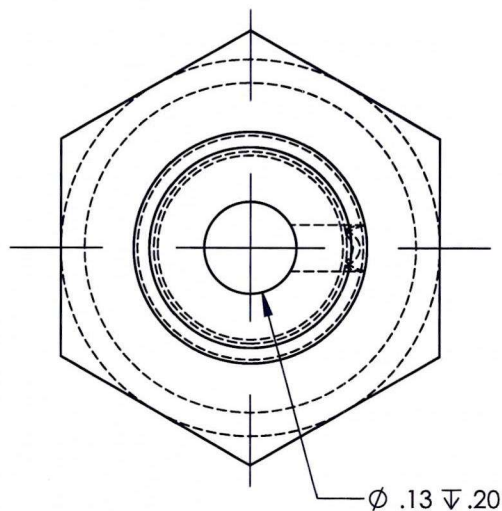
(-3)

TUBE

RED BARN MACHINE	
TITLE MAIN ROTOR DAMPER OIL ADAPTER	
DWG NO. RBW1205G00231-3G-3	REV 2B
MAT'L 6061	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH CLEAR ANODIZE
.X ± .1	SPEC MIL-A-8625, TYPE II, CLASS I
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AGUSTA
SCALE 2:1	DATE 2/23/2011
SHEET 3 OF 5	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
			APPROVED

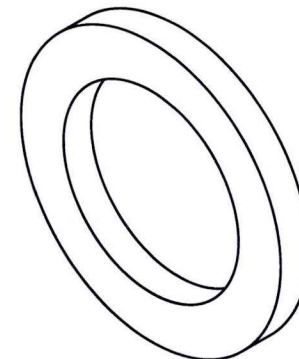
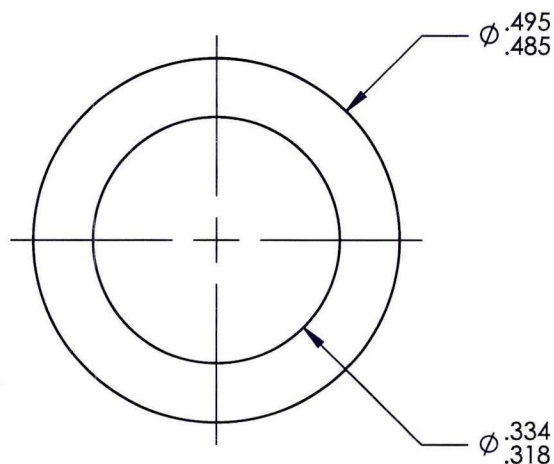
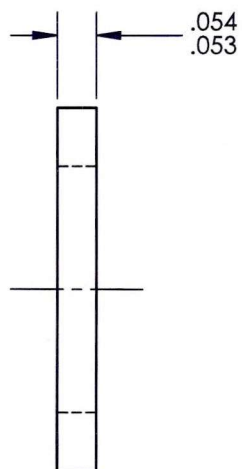


⑤
PLUG

RED BARN MACHINE	
TITLE MAIN ROTOR DAMPER OIL ADAPTER	
DWG NO. RBW1205G00231-3G-5	REV 2B
MAT'L ALUMINUM	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX $\pm .005$	HEAT TREAT
.XX $\pm .01$	FINISH
.X $\pm .1$	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AGUSTA
SCALE 4:1	DATE 2/23/2011
SHEET 4 OF 5	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
			APPROVED



(-7)

WASHER

 RED BARN MACHINE	
TITLE MAIN ROTOR DAMPER OIL ADAPTER	
DWG NO. RBW1205G00231-3G-7	REV 2B
MAT'L NYLON	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AGUSTA
SCALE 4:1	DATE 2/23/2011
SHEET 5 OF 5	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					